

5/25 SPLIT






DART AEROSPACE LTD		Work Order:	23301 A
Description: Fitting		Part Number:	D3299-1
Dwg: D3299 Rev. <sup>B</sup> <del>A</del> <i>04/01-11-16</i>		Qty:	<del>25</del> 24
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>AK</i>	05.05.25	25
2	MC	Cut blank: 2.200" long Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.625" Hex (M6061T6H1.625) Identify as D3299-1 Batch: <u>M17625</u>	<i>J.G</i>	05/07/25	26
3	MC	Turn as per Folio FA451 and Dwg D3299	<i>J.G</i>	05/07/26	26
4	QC2	Inspect parts as they come off the CNC machine	<i>J.G</i>	05/07/26	26
5	MV	Machine as per Folio FA451 and Dwg D3299	<i>BL</i>	05.08.06	26
6	QC2	Inspect parts as they come off the CNC machine	<i>BL</i>	05.08.06	26
7	QC8	Second check	<i>CP</i>	05/08/06	26
8	MV	Deburr	<i>BL</i>	05.08.06	26
9	PG	Issue P/O: <u>2008434</u> Anodize as per Dwg D3299 Possible Supplier: TNM Paint Material release note is required	<i>AK</i>	05/08/08	26
10	RG	Receive and Inspect for transit damage Ensure material release note is attached	<i>CL</i>	05/08/26	26
11	QC5	Inspect work to Step 10	<i>J</i>	05-08-30	24 P10
12	ST	Identify and Stock <i>Identify with DART Part #; Part # 0507A FINE Paint Requirement.</i>	<i>CL</i>	05/08/31	24
13	AC	Cost / part: <u>19.35</u>	<i>SUR</i>	05.09.01	24
14	DC	Close W/O <u>23.94</u> Inspect Level 21	<i>AK</i>	05/09/01	24

Rev	Date	Change	Revised By	Approved
A	04.10.04	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED  
*[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-30	11	Chamfered end damaged on fitting.	 	Samp: destroyed		 05-06-31	 05-06-30	 05-06-30

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 05/09/01

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DART AEROSPACE LTD		Work Order: 23301
Description: Fitting		Part Number: D3299-1
Inspection Dwg: D3299	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.250 / 1.237	✓			
0.476	+0.000/-0.005	0.476	✓			
0.550	+/-0.010	0.555	✓			
1.00	+/-0.030	0.997	✓			
2.10	+/-0.030	2.101	✓			
0.773	+/-0.010	.775				
0.10	+/-0.030	0.105	✓			
0.20	+/-0.030	0.200	✓			
0.550	+/-0.010	0.548	✓			
MOW Max = 0.573 Min = 0.565	Max = 0.573	0.566	✓			
Ø0.302	+0.005/-0.000	0.306	✓			
Ø0.688	+0.005/-0.000	.688	✓			
Ø0.580	+0.005/-0.000	.582	✓			
53°	+/-0.5°	53°	✓			
1.09	+/-0.030	1.120	✓			

Measured by: J.G/B6	Audited by: ml	Prototype Approval:	N/A
Date: 05/07/06	Date: 05/08/06	Date:	N/A

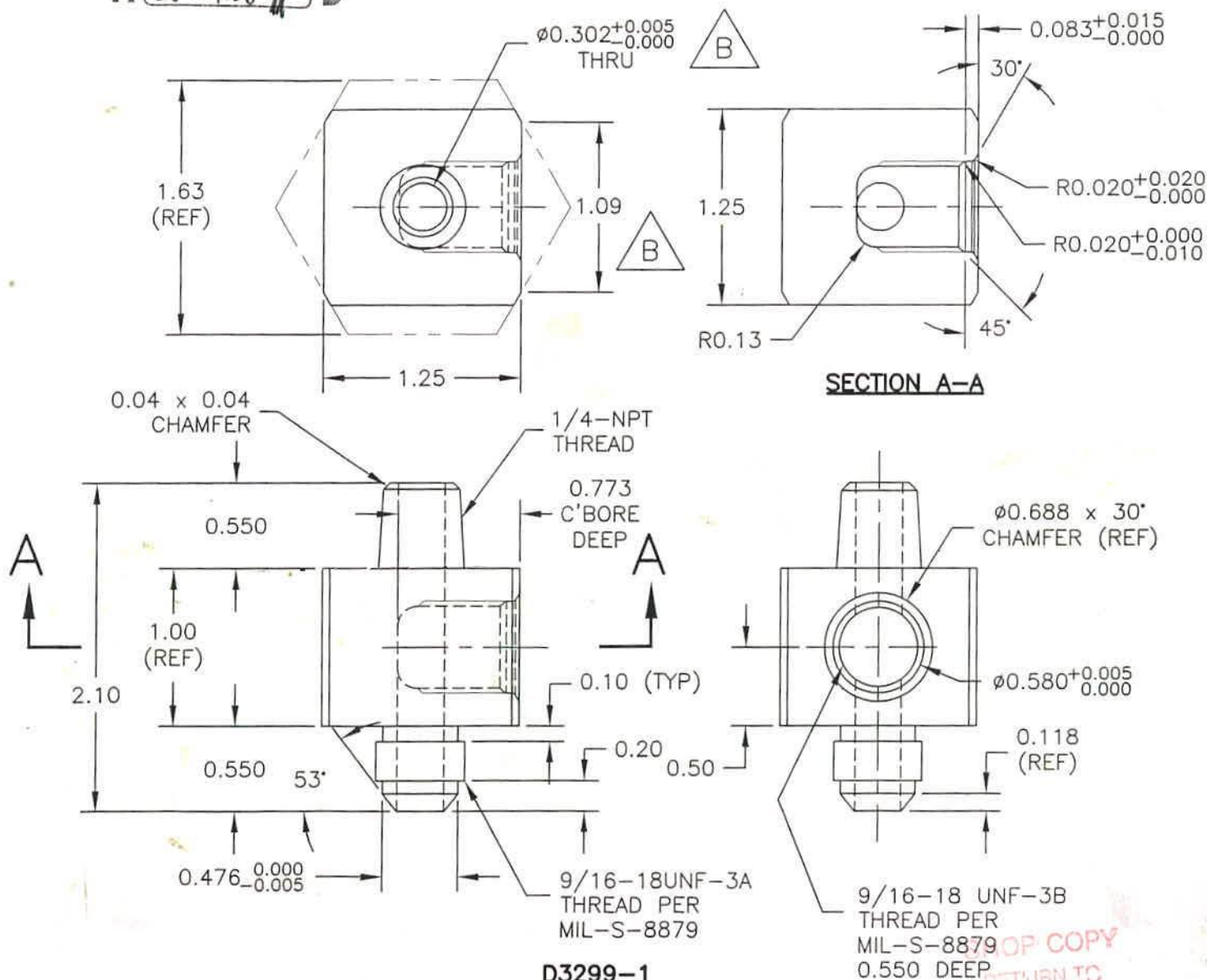
Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	
B	05.05.25	Ø0.302 was Ø0.312; 1.09 added	KJ/JLM	

RELEASED  
05/05/25



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 1 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; $\phi 0.302$ WAS $\phi 0.297$	

RELEASED  
05-04-28 #



D3299-1

D3299-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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TOP COPY  
RETURN TO  
DART AEROSPACE LTD  
HAWKESBURY, ONTARIO  
CANADA  
NOTICE  
WORK ORDER  
23301



# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

May 12, 2005  
04:28 pm

Work Order No : 0023301  
Project Name : D3299-1  
Project For : WK525  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3299-1  
Description : Fitting  
Manufactured : Yes  
Amount Req'd : 25  
Amount Done : 0  
Start Date : 05-12-05  
Est Finish Date : 06-23-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



21 chemin de l'Aviation, QC H9R 4Z2  
Telephone: (514) 429-7777 Fax: (514) 429-5108  
Certifié ISO 9001-2000 / ISO 9001-2000 certified  
Certifié NADCAP / NADCAP certified

42716

09-Aug-2005

CLIENT / CUSTOMER:

DART AEROSPACE LTD.  
1270 ABERDEEN STREET  
HAWKESBURY , ONTARIO  
K6A 1K7

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE

PURCHASE ORDER/  
NO. DE COMMANDE: 2008434



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	5	5	D3299-1 B23011	BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
2	26	26	D3299-1 B23011	BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
3	15	15	D3299-3 B23302	BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les articles énumérés ont été procédés accordément à l'inspection ci-haut.  
Les cartes de travail ont été remplies et sont disponibles pour consultation sur demande.

We hereby certify that the above parts have been processed in accordance with the above inspection.  
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: \_\_\_\_\_

Directeur de la Qualité / Q.A. Manager

